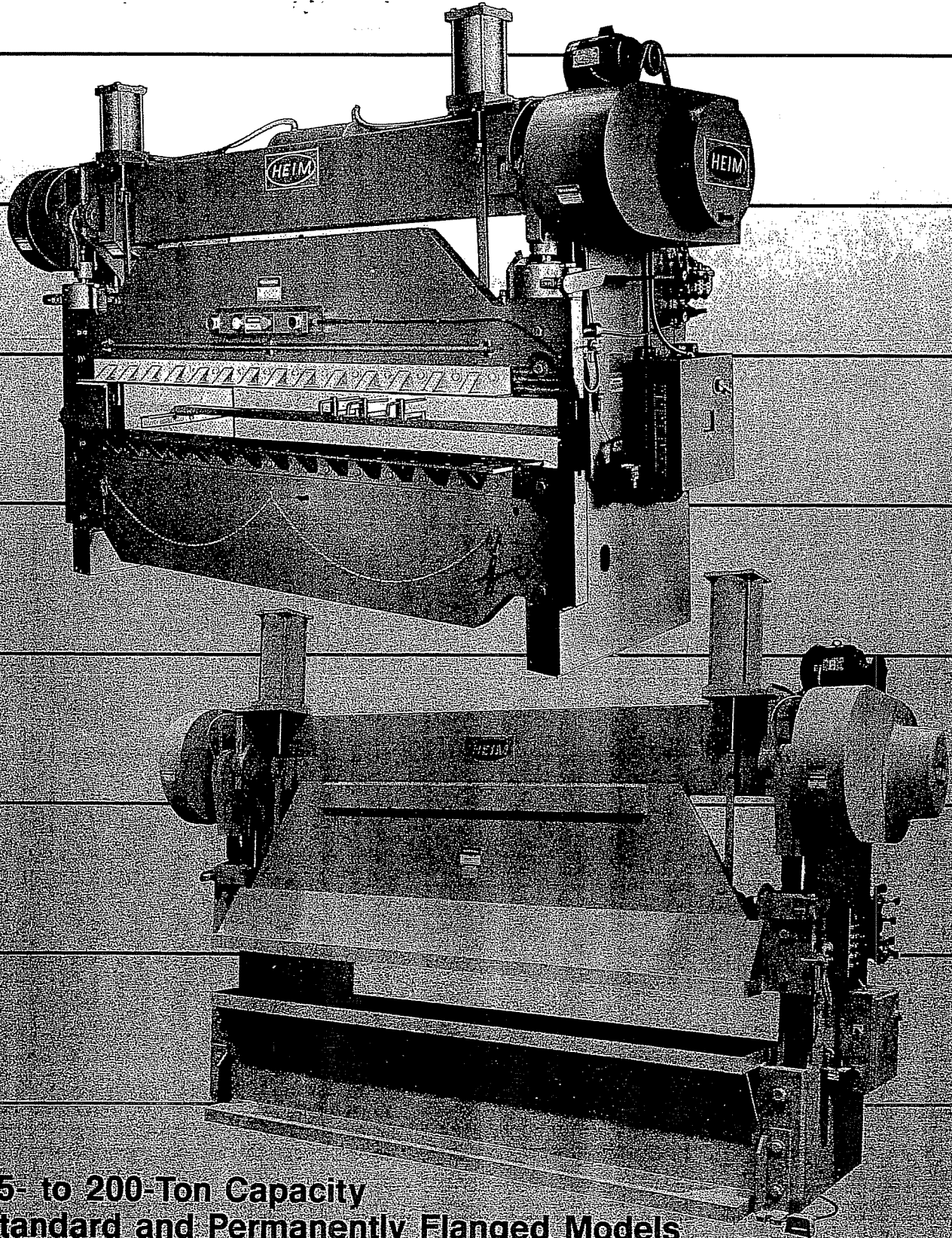


MECHANICAL PRESS BRAKES



35- to 200-Ton Capacity
Standard and Permanently Flanged Models

HEIM MECHANICAL PRESS BRAKES . . .

The economical choice for a wide variety of metal bending and stamping operations.

With 46 standard models to choose from, there is a Heim mechanical press brake to fit your specific production requirements. Heim press brakes are built for accuracy, dependability and durability for years of profitable use. Available in capacities from 35- to 200-ton, these versatile machines are equipped with the following quality features.

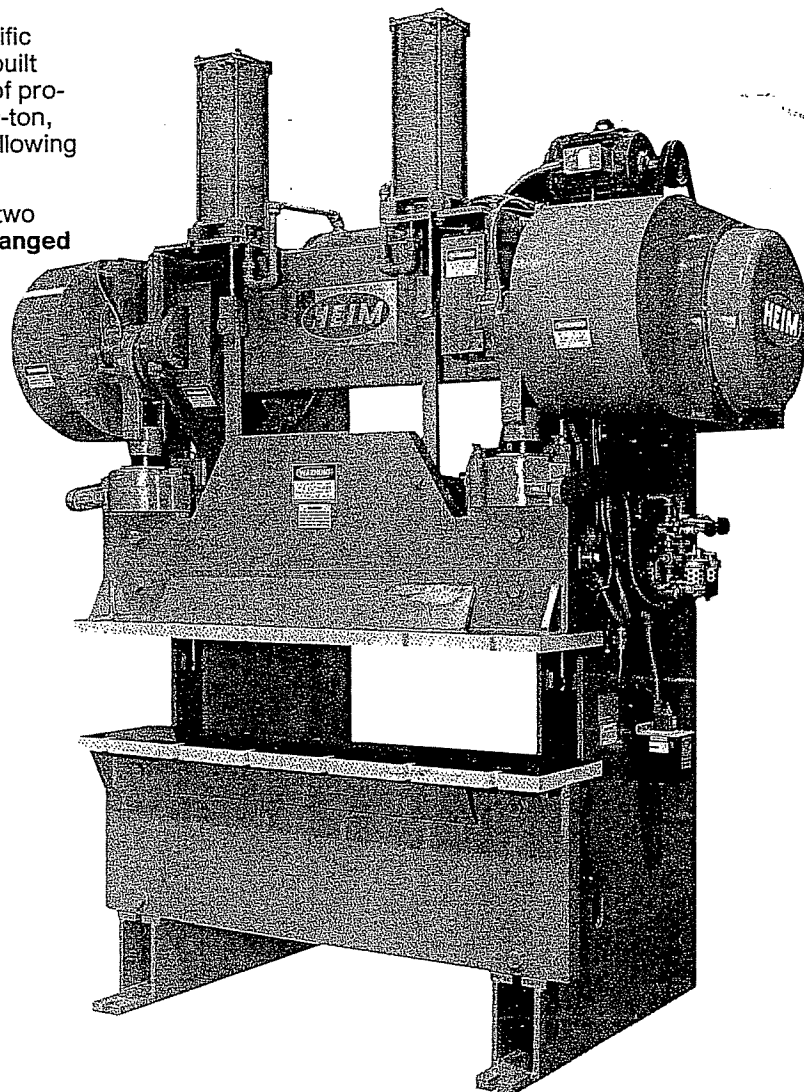
Heim mechanical press brakes are available in two types: **Standard Press Brake** and **Permanently Flanged** models.

Standard Features

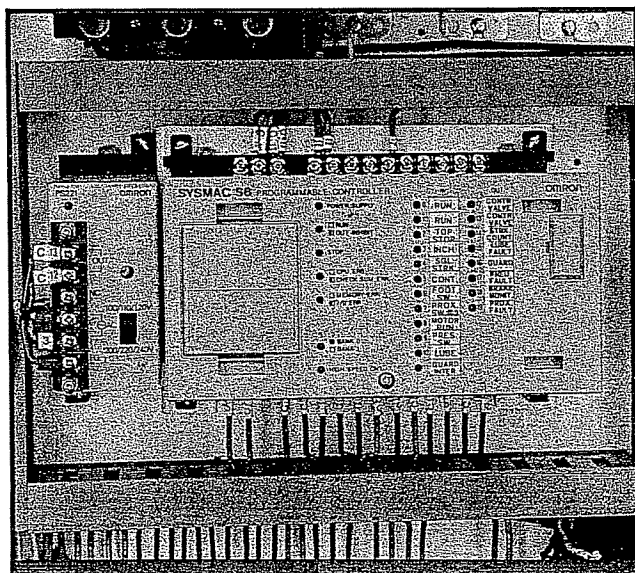
- Programmable Logic Controls (PLC)
- HI PRO™ low-inertia combination clutch and brake with 5-year warranty
- Double-wall construction
- 100% ram guidance through entire stroke length
- Intermediate helical gearing
- Manual, rear-operated back gauge
- Powered ram adjustment and indicator (45-ton models and larger)

Optional Features

- Automatic lubrication
- Manual, front-operated back gauge
- Powered, front-operated back gauge
- Reversing magnetic starter
- Air counterbalances
- Machining bed and ram for removable angles
- 5½" and 7½" removable angles
- Ram and bed extensions
- Powered ram adjustment (35-ton model)
- Optional stroke lengths (see specifications on back cover)



100-Ton, 6 Foot permanently flanged model.



Programmable Logic Control (PLC)

The PLC improves productivity and reliability by continuously monitoring all press brake operations. This self-diagnostic control system automatically warns and informs the operator of all press brake functions, including brake monitor, palm button, operating mode, lubrication, dual air valve, stop-on-top, motion detection, air pressure, etc. The brake is monitored and controlled during every stroke. The PLC automatically tracks every press brake movement, directing operation as determined by a pre-set program stored in the PLC's memory.

If a malfunction occurs, the PLC shuts down the press brake. An indicator light immediately directs the operator to the source of the problem, making trouble shooting easy and keeping downtime to a minimum.

Programmable Logic Controller with LED indicator lights.

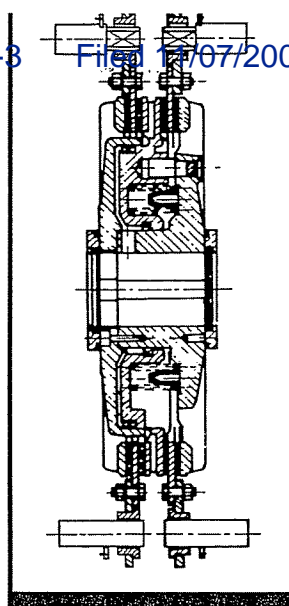
HI PRO™ Low Inertia Combination Clutch and Brake

Withstanding the stress of frequent starts and stops, this low inertia combination clutch and brake is designed for maximum heat dissipation. This important feature significantly reduces wear on the clutch and brake, allows high start/stop frequency capability and high allowable rotational speed.

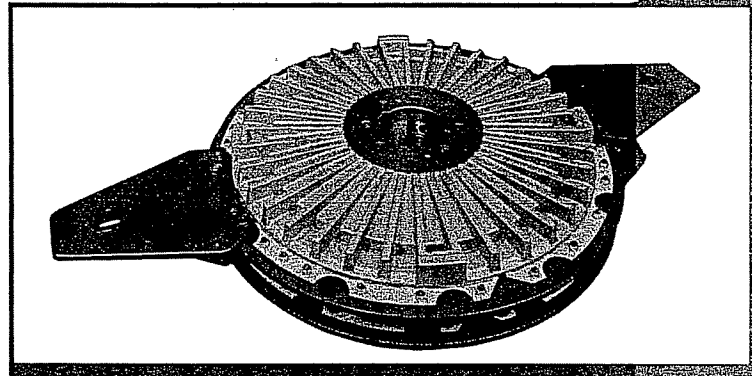
The HI PRO clutch and brake has only a fraction of the inertia found in other clutch and brake units where the clutch and brake must be started and stopped at every cycle. The brake portion of the unit is stationary, therefore in starting or stopping, there is minimum inertia to be overcome. Large air flow passages enable natural convection currents to dissipate heat.

Fast stopping times of the brake protect expensive dies. If either the air or electrical supply fails, the clutch will automatically disengage and the brake is applied. For ease of replacement, split clutch and brake linings are standard.

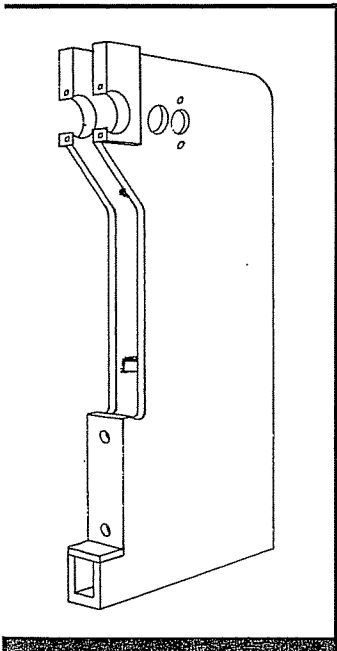
The HI PRO clutch and brake comes with a 5-year warranty. Contact your Heim representative for details.



Cross section of HI PRO™ clutch and brake.



The HI PRO clutch and brake comes with a 5-year warranty.



Double-Wall Construction

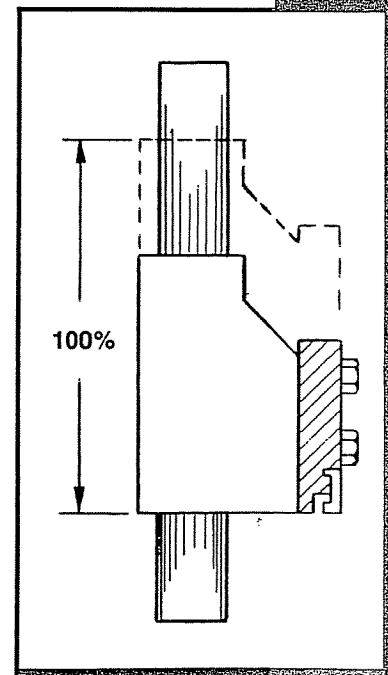
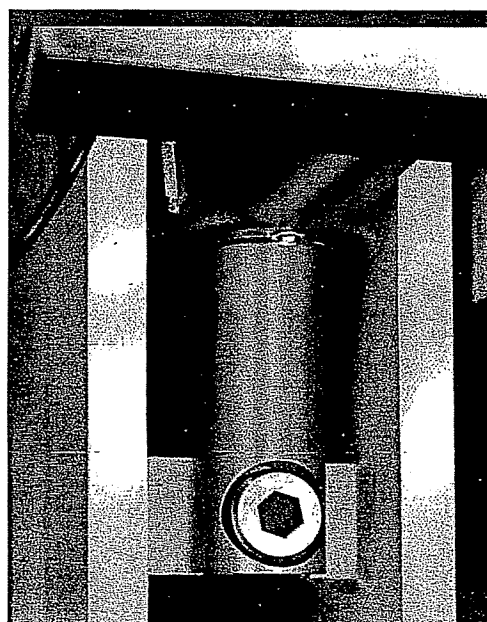
The end frames of a Heim press brake are constructed with a double-wall design for years of continued component alignment. This box-type design provides maximum stability and support by resisting deflections, twisting motions, and vibrations. While under load, the frame assures accuracy of part production and maximum die life.

Circular guides control the movement of the ram for the full length of each stroke.

Ram Guidance

For maximum accuracy, the ram of a Heim press brake is guided by circular guides with bronze bushings along 100% of the travel. This feature guides the movement of the ram for the full length of each stroke. Left-to-right and front-to-back tolerances are controlled, assuring proper ram and bed alignment. Maintaining parallel alignment protects dies and assures quality part production.

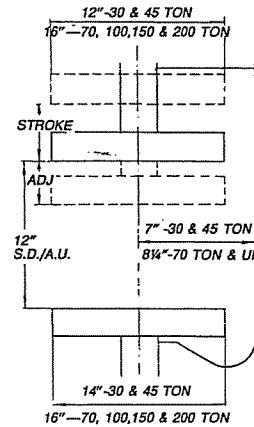
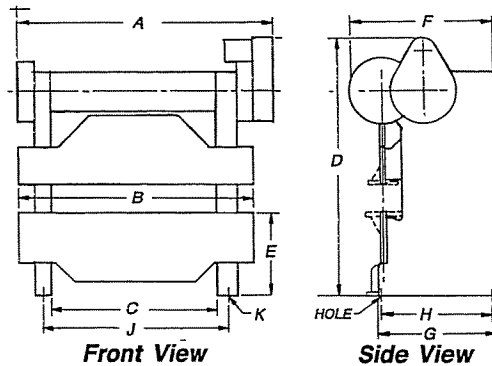
Massive circular guide and connecting bolt.



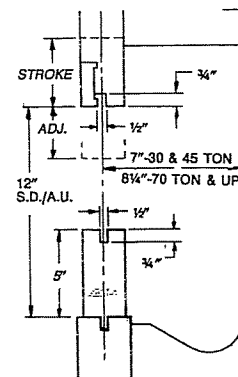
SPECIFICATIONS

MODEL	BENDING CAPACITY (air bend)	TONNAGE		STANDARD STROKE	OPTIONAL STROKES AVAILABLE	STROKES PER MINUTE	RAM ADJUSTMENT	DIE SPACE (SHUT-HEIGHT) SDAU	FLANGE WIDTH	DRIVE MOTOR (HP)	DIMENSIONS (Inches)												SHIPPING WEIGHT LBS. APPROX.
		Near Bottom	Mid Stroke								A	B	C	D	E	F	G	H	J	K	L		
35-4 35-6 35-8	48" x 12 GA. 72" x 14 GA.	30	20	2"	3", 4" & 5"	40	2½"	12"	Ram 12" Bed 14"	2	71 95 119	54 78 102	38 62 86	94	32	38	30	28	42 66 90	1" Dia.	2"	4000 4900 5800	
45-4 45-6 45-8 45-10	60" x 10 GA. 72" x 12 GA. 96" x 14 GA.	45	30	2"	3", 4" & 5"	40	2½"	12"	Ram 12" Bed 14"	2	71 95 119 143	54 78 102 126	38 62 86 110	94	32	44	36	34	42 66 90 114	1" Dia.	2"	4500 5400 6500 7500	
75-6 75-8 75-10 75-12	48" x 1/4" 60" x 3/16" 96" x 10 GA. 120" x 12 GA.	70	45	3"	3", 4" & 5"	40	3½"	12"	Ram 16" Bed 16"	5	90 114 138 162	72 96 120 144	52 76 100 124	112	32	52	42	40	59 83 107 131	1¼" Dia.	3"	8200 9700 11600 13600	
100-6 100-8 100-10 100-12	60" x 1/4" 96" x 3/16" 120" x 10 GA. 144" x 12 GA.	100	65	3"	4", 5" & 6"	40	3½"	12"	Ram 16" Bed 16"	7½	90 114 138 162	72 96 120 144	52 76 100 124	112	32	58	48	46	59 83 107 131	1¼" Dia.	3"	10500 11800 13500 17000	
150-6 150-8 150-10 150-12	60" x 5/16" 84" x 1/4" 120" x 3/16" 168" x 10 GA.	150	100	3"	4", 5" & 6"	25	5"	12"	Ram 16" Bed 16"	15	100 124 148 172	78 102 126 150	54 78 102 126	138	37	75	67½	62½	62 86 110 134	1½" Dia.	4"	17000 19000 21500 24000	
200-6 200-8 200-10 200-12	60" x 3/8" 84" x 5/16" 120" x 1/4" 168" x 3/16"	200	140	3"	4", 5" & 6"	25	5"	12"	Ram 16" Bed 16"	20	101 125 149 173	78 102 126 150	53 77 101 125	138	37	75	67½	62½	62 86 110 134	1½" Dia.	4"	20000 22000 24500 28500	

Tonnage in shaded areas are for V die openings eight times the metal thickness.



Permanently Flanged Press Brake



Standard Press Brake

TONNAGE TABLE

THICKNESS OF METAL		WIDTH OF V DIE OPENING IN INCHES																								
GAGE	INCHES	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 1/2	1 3/4	2	2 1/4	2 1/2	3	3 1/2	4	5	6	7	8	10	12
20	0.036	3.1	2.3	1.7	1.4	1.1																				
18	0.048	5.3	4.0	3.0	2.5	2.2	1.7	1.3																		
16	0.060	9.6	7.1	5.6	4.5	3.8	2.8	2.2	1.8	1.5																
14	0.075		11.9	9.2	7.6	6.3	4.7	3.5	3.0	1.5	2.1	1.8														
12	0.105				16.7	13.1	9.7	8.0	6.5	5.6	4.6	4.1	3.2													
11	0.120					19.2	14.2	11.1	9.0	7.5	6.3	5.5	4.4	2.9												
10	0.135						18.6	14.5	11.9	9.9	8.5	7.3	5.8	4.0												
3/16	0.188							27.4	23.1	19.3	16.4	14.3	11.2	7.5	5.7	4.4										
1/4	0.250								39.4	33.3	29.5	22.7	15.4	11.4	9.0	7.4	6.1									
5/16	0.313									50.4	39.8	27.0	19.7	15.3	12.7	10.5	7.7									
3/8	0.375										61.6	42.3	30.9	24.0	19.6	16.3	12.3	9.5								
7/16	0.438											61.7	45.8	35.4	28.6	24.4	17.3	14.8	11.2							
1/2	0.500												85.2	63.6	48.8	39.7	33.3	24.6	19.4	15.9	13.1					
5/8	0.625													110.0	86.2	70.0	58.3	43.1	33.3	27.4	23.3	16.9				
3/4	0.750														138.0	110.0	93.0	68.7	53.5	43.6	36.5	27.1	21.0			
7/8	0.875															165.0	137.0	104.0	80.7	64.6	52.9	39.7	31.6			
1	1.000																197.0	143.0	113.0	91.2	76.2	56.3	44.2			
TONS REQUIRED PER LINEAR FOOT TO BEND MILD STEEL HAVING 60,000 PSI TENSILE STRENGTH																										

TONS REQUIRED PER LINEAR FOOT TO BEND MILD STEEL HAVING 60,000 PSI TENSILE STRENGTH.

HEIM

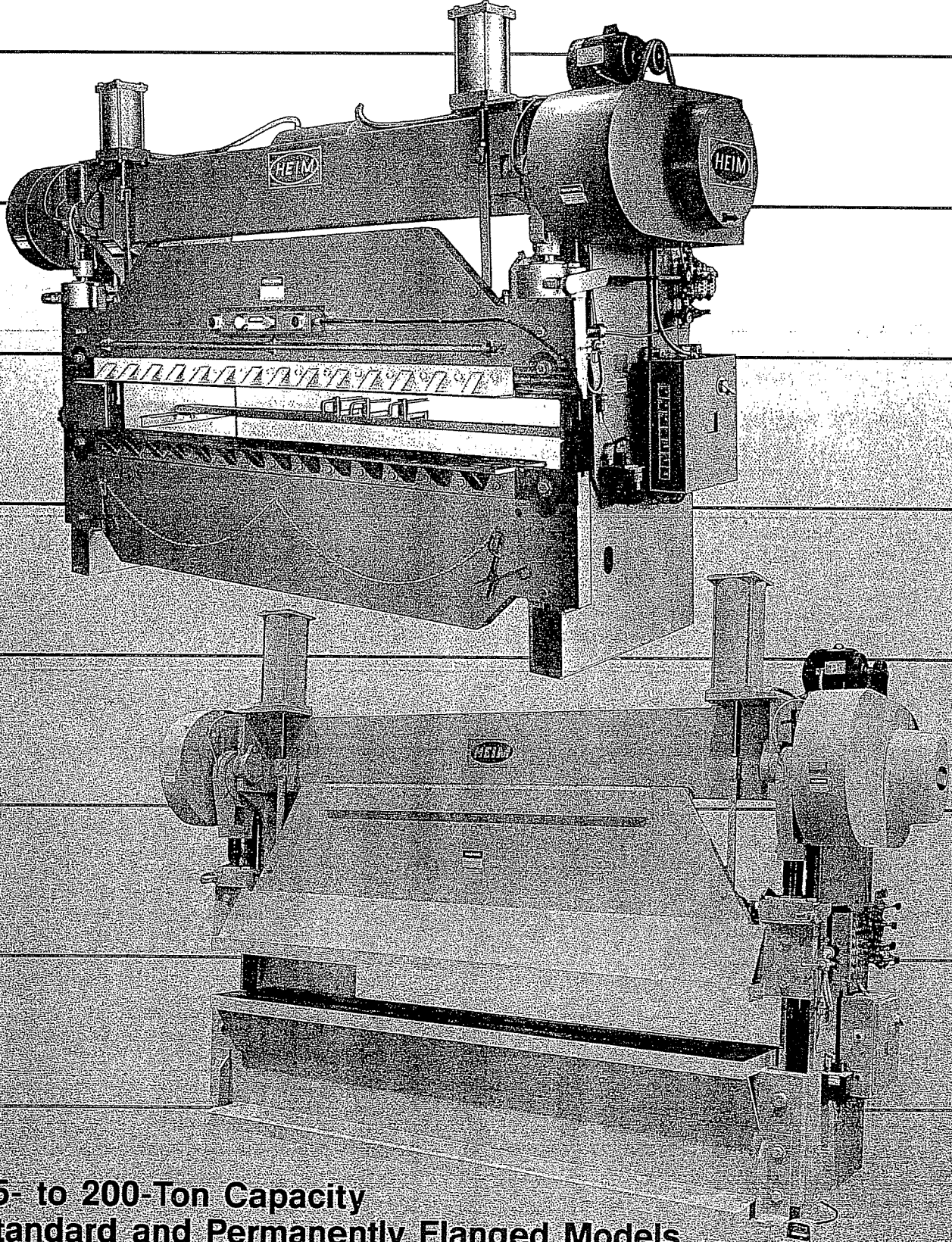
For more information contact:

Heim L.P. 6360 West 73rd Street, Chicago, Illinois 60638
708-496-7450 Fax 708-496-7428 Parts Fax 708-496-0708

Heim L.P. reserves the right to change the design or details of its products without notice. Point of operation safety guarding or devices are the sole responsibility of the employer (user) of the machine as provided in ANSI B-11 1-1988 as published by the American National Standards Institute Inc., 1430 Broadway, New York, NY 10018 and OSHA regulations.

Cat MPB-32 5-93 4M © 1993 Heim L.P.

MECHANICAL PRESS BRAKES



35- to 200-Ton Capacity
Standard and Permanently Flanged Models

HEIM MECHANICAL PRESS BRAKES . . .

The economical choice for a wide variety of metal bending and stamping operations.

With 46 standard models to choose from, there is a Heim mechanical press brake to fit your specific production requirements. Heim press brakes are built for accuracy, dependability and durability for years of profitable use. Available in capacities from 35- to 200-ton, these versatile machines are equipped with the following quality features.

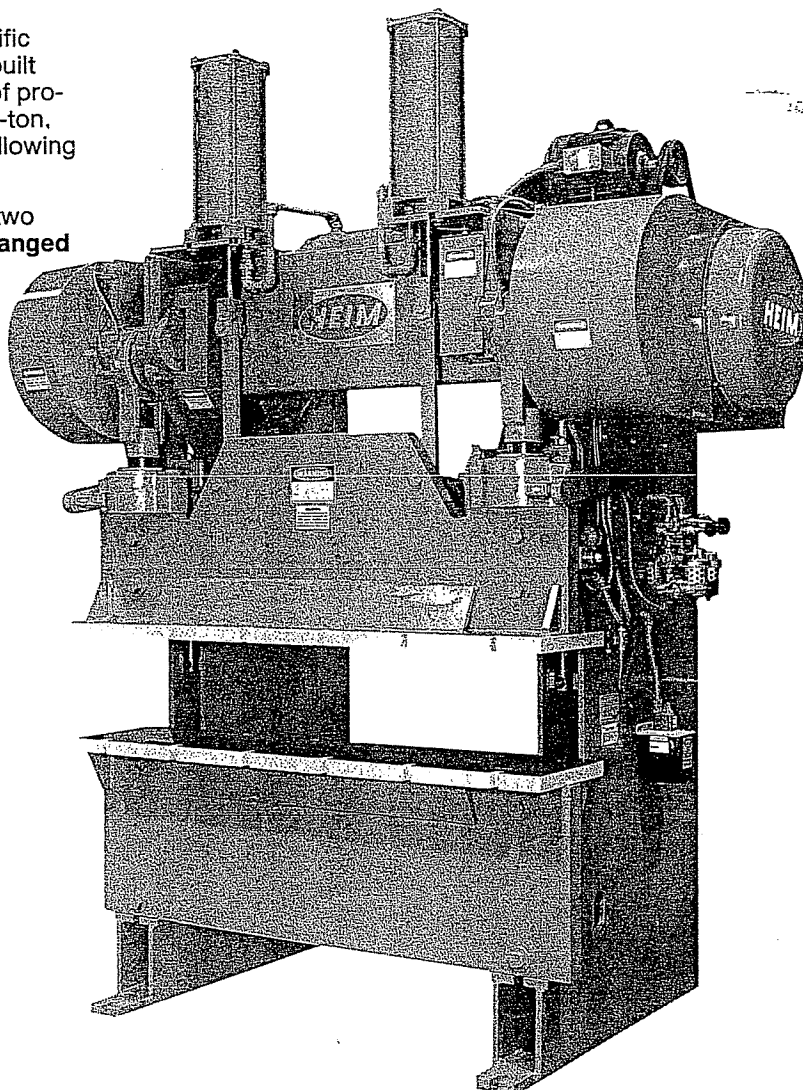
Heim mechanical press brakes are available in two types: **Standard Press Brake** and **Permanently Flanged models**.

Standard Features

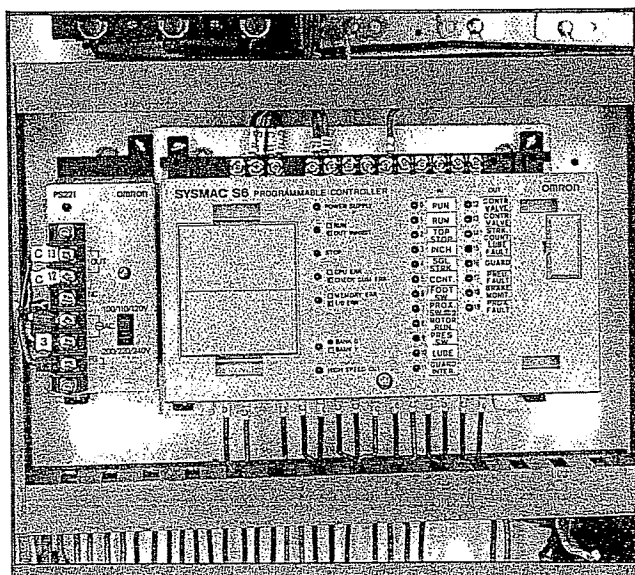
- Programmable Logic Controls (PLC)
- HI PRO™ low-inertia combination clutch and brake with 5-year warranty
- Double-wall construction
- 100% ram guidance through entire stroke length
- Intermediate helical gearing
- Manual, rear-operated back gauge
- Powered ram adjustment and indicator (45-ton models and larger)

Optional Features

- Automatic lubrication
- Manual, front-operated back gauge
- Powered, front-operated back gauge
- Reversing magnetic starter
- Air counterbalances
- Machining bed and ram for removable angles
- 5½" and 7½" removable angles
- Ram and bed extensions
- Powered ram adjustment (35-ton model)
- Optional stroke lengths (see specifications on back cover)



100-Ton, 6 Foot permanently flanged model.



Programmable Logic Control (PLC)

The PLC improves productivity and reliability by continuously monitoring all press brake operations. This self-diagnostic control system automatically warns and informs the operator of all press brake functions, including brake monitor, palm button, operating mode, lubrication, dual air valve, stop-on-top, motion detection, air pressure, etc. The brake is monitored and controlled during every stroke. The PLC automatically tracks every press brake movement, directing operation as determined by a pre-set program stored in the PLC's memory.

If a malfunction occurs, the PLC shuts down the press brake. An indicator light immediately directs the operator to the source of the problem, making trouble shooting easy and keeping downtime to a minimum.

Programmable Logic Controller with LED indicator lights.

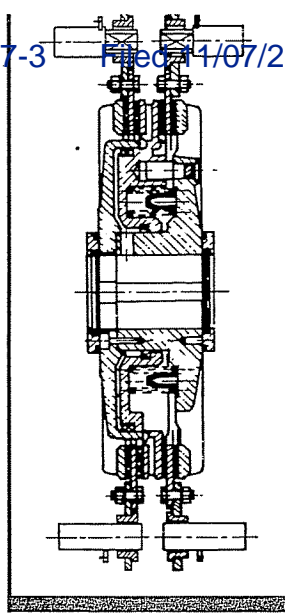
HI PRO™ Low Inertia Combination Clutch and Brake

Withstanding the stress of frequent starts and stops, this low inertia combination clutch and brake is designed for maximum heat dissipation. This important feature significantly reduces wear on the clutch and brake, allows high start/stop frequency capability and high allowable rotational speed.

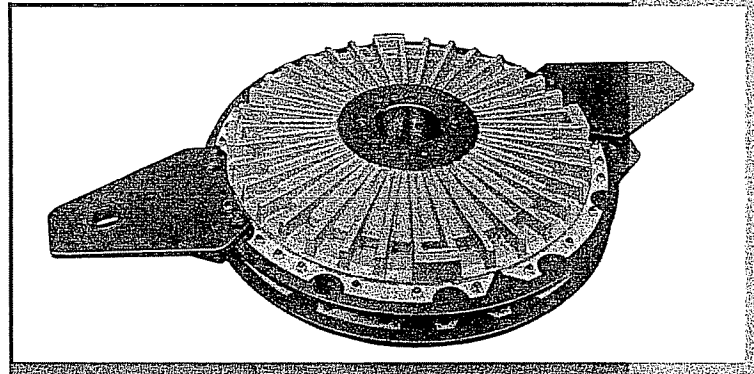
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Fast stopping times of the brake protect expensive dies. If either the air or electrical supply fails, the clutch will automatically disengage and the brake is applied. For ease of replacement, split clutch and brake linings are standard.

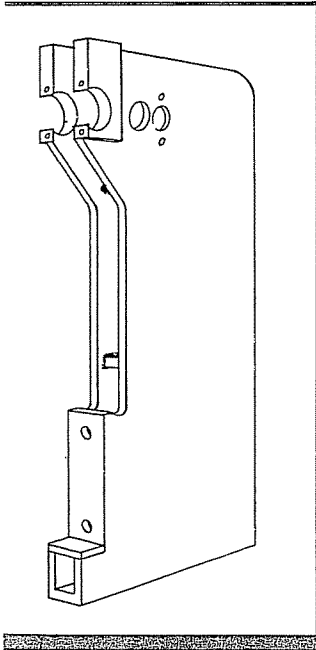
The HI PRO clutch and brake comes with a 5-year warranty. Contact your Heim representative for details.



Cross section of HI PRO™ clutch and brake.



The HI PRO clutch and brake comes with a 5-year warranty.



Double-Wall Construction

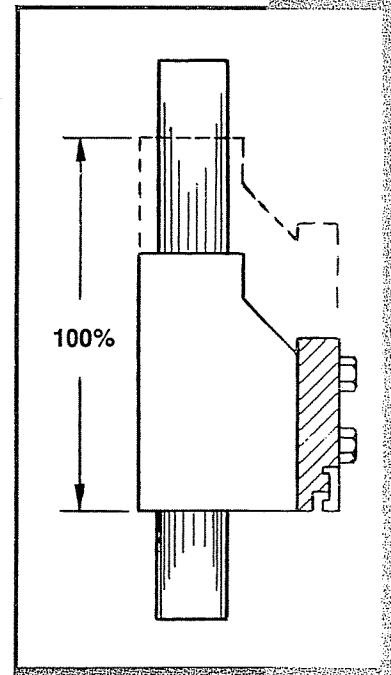
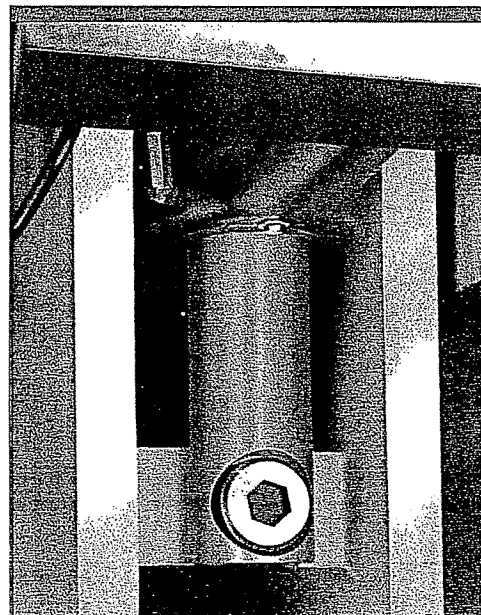
The end frames of a Heim press brake are constructed with a double-wall design for years of continued component alignment. This box-type design provides maximum stability and support by resisting deflections, twisting motions, and vibrations. While under load, the frame assures accuracy of part production and maximum die life.

Circular guides control the movement of the ram for the full length of each stroke.

Ram Guidance

For maximum accuracy, the ram of a Heim press brake is guided by circular guides with bronze bushings along 100% of the travel. This feature guides the movement of the ram for the full length of each stroke. Left-to-right and front-to-back tolerances are controlled, assuring proper ram and bed alignment. Maintaining parallel alignment protects dies and assures quality part production.

Massive circular guide and connecting bolt.

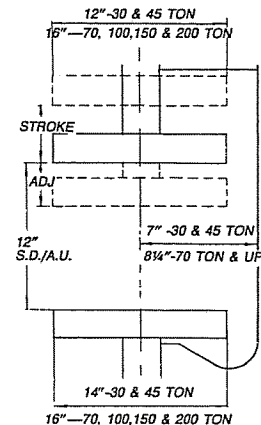
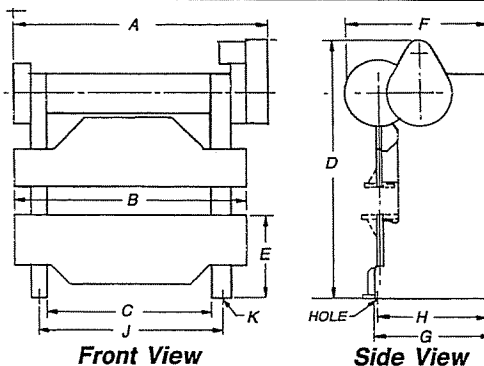


SPECIFICATIONS

MODEL	BENDING CAPACITY (air bend)	TONNAGE		STANDARD STROKE	OPTIONAL STROKES AVAILABLE	STROKES PER MINUTE	RAM ADJUSTMENT	DIE SPACE (SHUT HEIGHT) SDAU	FLANGE WIDTH	DRIVE MOTOR (HP)	DIMENSIONS (Inches)											SHIPPING WEIGHT LBS. APPROX.
		Near Bottom	Mid Stroke								A	B	C	D	E	F	G	H	J	K	L	
35-4 35-6 35-8	48" x 12 GA. 72" x 14 GA.	30	20	2"	3", 4" & 5"	40	2 1/2"	12"	Ram 12" Bed 14"	2	71 95 119	54 78 102	38 62 86	94	32	38	30	28	42 66 90	1" Dia.	2"	4000 4900 5800
45-4 45-6 45-8 45-10	60" x 10 GA. 72" x 12 GA. 96" x 14 GA.	45	30	2"	3", 4" & 5"	40	2 1/2"	12"	Ram 12" Bed 14"	2	71 95 119 143	54 78 102 126	38 62 86 110	94	32	44	36	34	42 66 90 114	1" Dia.	2"	4500 5400 6500 7500
75-6 75-8 75-10 75-12	48" x 1 1/4" 60" x 3/16" 96" x 10 GA. 120" x 12 GA.	70	45	3"	3", 4" & 5"	40	3 1/2"	12"	Ram 16" Bed 16"	5	90 114 138 162	72 96 120 144	52 76 100 124	112	32	52	42	40	59 83 107 131	1 1/4" Dia.	3"	8200 9700 11600 13600
100-6 100-8 100-10 100-12	60" x 1 1/4" 96" x 3/16" 120" x 10 GA. 144" x 12 GA.	100	65	3"	4", 5" & 6"	40	3 1/2"	12"	Ram 16" Bed 16"	7 1/2	90 114 138 162	72 96 120 144	52 76 100 124	112	32	58	48	46	59 83 107 131	1 1/4" Dia.	3"	10500 11800 13500 17000
150-6 150-8 150-10 150-12	60" x 5/16" 84" x 1/4" 120" x 3/16" 168" x 10 GA.	150	100	3"	4", 5" & 6"	25	5"	12"	Ram 16" Bed 16"	15	100 124 148 172	78 102 126 150	54 78 102 126	138	37	75	67 1/2	62 1/2	62 86 110 134	1 1/2" Dia.	4"	17000 19000 21500 24000
200-6 200-8 200-10 200-12	60" x 3/8" 84" x 5/16" 120" x 1/4" 168" x 3/16"	200	140	3"	4", 5" & 6"	25	5"	12"	Ram 16" Bed 16"	20	101 125 149 173	78 102 126 150	53 77 101 125	138	37	75	67 1/2	62 1/2	62 86 110 134	1 1/2" Dia.	4"	20000 22000 24500 28500

Tonnage in shaded areas are for V die openings eight times the metal thickness.

TONNAGE TABLE



Permanently Flanged Press Brake

THICKNESS OF METAL	WIDTH OF V DIE OPENING IN INCHES																			
GAGE INCHES	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 1/2	2	2 1/2	3	3 1/2	4	5	6	7
20	0.036	3.1	2.3	1.7	1.4	1.1														
18	0.048	5.3	4.0	3.0	2.5	2.2	1.7	1.3												
16	0.060	9.6	7.1	5.6	4.5	3.8	2.8	2.2	1.8	1.5										
14	0.075		11.9	9.2	7.6	6.3	4.7	3.5	3.0	2.1	1.6									
12	0.105			16.7	13.1	9.7	8.0	6.5	5.6	4.6	4.1	3.2								
11	0.120				19.2	14.2	11.1	9.0	7.5	6.3	5.5	4.4	2.9							
10	0.135					18.6	14.5	11.9	9.9	8.5	7.3	5.8	4.0							
3/16	0.188						27.4	23.1	19.3	16.4	14.3	11.2	7.5	5.7	4.4					
1/4	0.250							39.4	33.3	29.5	22.7	15.4	11.4	9.0	7.4	6.1				
5/16	0.313								50.4	39.8	27.0	19.7	15.3	12.7	10.5	7.7				
3/8	0.375									61.6	42.3	30.9	24.0	19.6	16.3	12.3	9.5			
7/16	0.438										61.7	45.8	35.4	28.6	24.4	17.3	14.8	11.2		
1/2	0.500											85.2	63.6	48.8	39.7	33.3	24.6	19.4	15.9	13.1
5/8	0.625												110.0	86.2	70.0	58.3	43.1	33.3	27.4	23.3
3/4	0.750													138.0	110.0	93.0	68.7	53.5	43.6	36.5
7/8	0.875														165.0	137.0	104.0	80.7	64.6	52.9
1	1.000															197.0	143.0	113.0	91.2	76.2

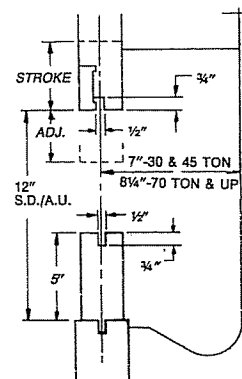
TONS REQUIRED PER LINEAR FOOT TO BEND MILD STEEL HAVING 60,000 PSI TENSILE STRENGTH.



For more information contact:

Heim Corp. 6360 West 73rd Street, Chicago, IL 60638
(312) 496-7450 Telex 25-053 Telefax (312) 496-7428

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Cat MPB-32 3M 5/88 ©1988 Heim Corp.



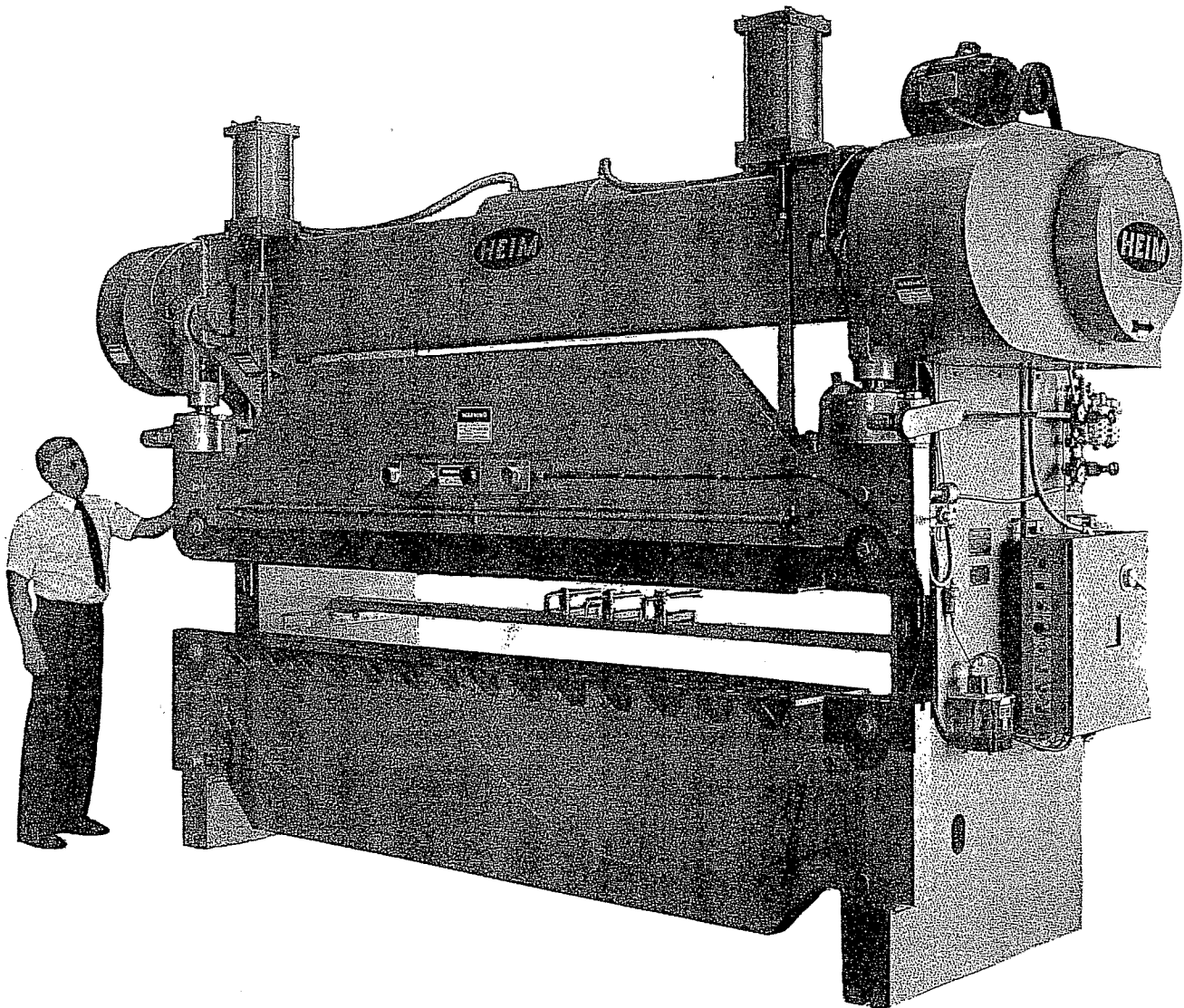
Standard Press Brake

PRICE LIST

EFFECTIVE 10/15/84

MECHANICAL PRESS BRAKES

35, 45, 75, 100, 150, 200 TON



FEATURING HI-TECH CNC CONTROLS AS STANDARD EQUIPMENT



MORE PRESS FOR LESS

CAPACITY TONS		35 TON			45 TON				75 TON			
LENGTH OF BED AND RAM		4'6"	6'6"	8'6"	4'6"	6'6"	8'6"	10'6"	6'	8'	10'	12'*
DISTANCE BETWEEN HOUSINGS		38"	62"	86"	38"	62"	86"	110"	52"	76"	100"	124"
STANDARD PRESS BRAKE PRICE INCL. CNC CONTROL		14,525	15,065	15,695	16,230	16,750	17,225	18,210	22,195	22,760	23,410	23,790
ONE SHOT LUBRICATION		195	195	195	STD	STD	STD	STD	STD	STD	STD	STD
AUTOMATIC LUBRICATION		315	315	315	315	315	315	315	315	315	315	315
RAM INDICATORS		260	260	260	STD	STD	STD	STD	STD	STD	STD	STD
POWER RAM ADJUSTMENT		480	480	480	STD	STD	STD	STD	STD	STD	STD	STD
STROKE CHANGE OTHER THAN STANDARD	2"	STD	STD	STD	STD	STD	STD	STD	-	-	-	-
	3"	315	315	315	315	315	315	315	STD	STD	STD	STD
	4"	385	385	385	385	385	385	385	460	460	460	460
	5"	500	500	500	500	500	500	500	630	630	630	630
	6"	NA	NA	NA	NA	NA	NA	NA	880	880	880	880
REVERSING STARTER		315	315	315	315	315	315	315	385	385	385	385
MANUAL FRONT OPERATED BACK GAUGE		905	905	905	905	905	905	905	975	975	975	975
AIR COUNTERBALANCES		1250	1250	1250	1250	1250	1250	1250	1250	1250	1250	1250
MACHINING BED AND RAM FOR ANGLES**		565	625	740	565	625	740	835	625	740	835	905
SET OF FOUR 5-1/2" ANGLES		1025	1580	2085	1025	1580	2085	2465	1580	2085	2465	2870
SET OF FOUR 7-1/2" ANGLES		-	-	-	-	-	-	-	-	-	-	-
SPECIAL ONE COLOR PAINT PAINT FURNISHED BY CUST. PAINT FURNISHED BY HEIM		110 140	110 140	110 140	110 140	110 140	110 140	110 140	140 175	140 175	140 175	140 175
CONTROL VARIATIONS PALM BUTTONS IN PLACE OF FOOT SWITCH FT. SWITCH & PALM BTNS. WITH KEY SELECTOR SWITCH		290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485
SHIPPING WEIGHT APPROX. POUNDS		4,000	4,900	5,800	4,500	5,400	6,500	7,500	8,200	9,700	11,600	13,600

*AIR COUNTERBALANCES RECOMENDED
**REQUIRES ONE SET OF PALM BUTTONS

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100 TON				150 TON				200 TON			
6'	8'	10'	12'*	6'6"	8'6"	10'6"*	12'6"*	6'6"	8'6"	10'6"*	12'6"*
52"	76"	100"	124"	54"	78"	102"	126"	53"	77"	101"	125"
22,760	23,140	23,840	24,020	32,030	32,750	33,470	35,200	35,630	28,150	39,275	41,120
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
315	315	315	315	315	315	315	315	315	315	315	315
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
—	—	—	—	—	—	—	—	—	—	—	—
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
460	460	460	460	550	550	550	550	550	550	550	550
630	630	630	630	740	740	740	740	740	740	740	740
880	880	880	880	985	985	985	985	985	985	985	985
385	385	385	385	505	505	505	505	505	505	505	505
975	975	975	975	975	975	975	975	975	975	975	975
1250	1250	1250	1250	1560	1560	1560	1560	1560	1560	1560	1560
625	740	835	905	715	805	900	975	715	805	900	975
1580	2085	2465	2870	—	—	—	—	—	—	—	—
—	—	—	—	1880	2550	3125	3750	1880	2550	3125	3750
140 175	140 175	140 175	140 175	175 210	175 210	175 210	175 210	175 210	175 210	175 210	175 210
290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485
10,500	11,800	13,500	17,000	17,000	19,000	21,500	24,000	20,000	22,000	24,500	28,500

NOTE: POINT OF OPERATION SAFETY GUARDING
IS THE SOLE RESPONSIBILITY OF THE USER
OF THE MACHINE.

Standard Features • New PC Control • Magnetic Starter (Non Rev.) Including Disconnect Switch With Circuit Breaker • Brake Monitor • One Foot Switch Control (Inching, Single Stroke and Auto Jog) • Part Revolution Low Inertia Air Clutch and Combination Brake (35/45 Ton) • Part Revolution Low Inertia Air Clutch and Caliper Disc Brake (75 Thru 200 Ton) • Pre Set Jog Mode • Adjustable Pre Set Job Mode to Help Prevent Whip L That Causes Back Bending of Material • Double Reduction Twin Drive Gears • High Strength Eccentric Crank Shaft • Rigid One Piece Ra • Massive One Piece Bed • Rigid, Double Plate, Box Girder Side Frames • Motorized Ram Adjustment and Ram Indicators (45 Thru 200 Tc • Back Gauges and Fingers For Fine Adjustment • Sectional Ram Clamps • Gear and Flywheel Guards • Lower Die Block • Tilting Ram (Feature) • Replaceable Bronze Ball Socket • Stroke (2" Std. 35/45 Ton, 3" Std. 75 Thru 200 Ton) • Air Line Filter, Regulator and Lubricat

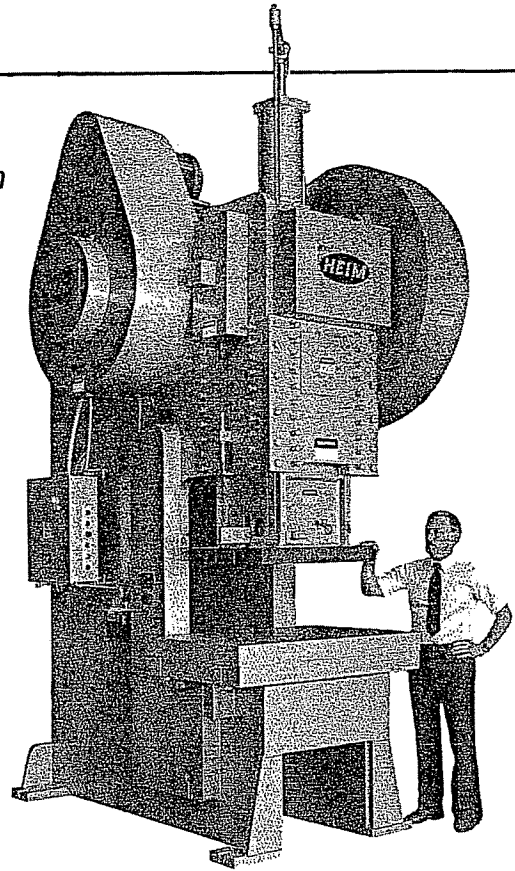
OTHER HEIM PRESSES

OBI, GAP and DEEP THROAT GAP PRESSES

Featuring Hi-Tech CNC Controls For Reliable Press Operation

Standard Features

- New PC Control
- One Operator Station Unmounted (Inching, Single Stroke and Continuous)
- Brake Monitor
- Magnetic Starter (Non Rev.) Including Disconnect Switch With Circuit Breaker
- Dead Motor Inch Control
- Rugged All Welded Steel Frame Construction
- Complete Flywheel, Motor, Guards, Pulley V Belts and Brackets (Fully Mounted)
- Part Revolution, Low Inertia Air Clutch and Caliper Disc Brake
- Bolster Plate (Plain and Mounted)
- Stroke (2" Std. on 32 Ton, 3" Std. on 55, 70, 95 and 120 Ton, 4" Std. on 160 and 200 Ton)
- Knock Out Bar Arrangement
- Multiple Vee Non Metallic Gibbing (32 Thru 120 Ton)
- 8 Point Adjustable, Bronze Gibbing (160/200 Ton)
- One Shot Lube System (95 Thru 200 Ton)
- Air Counter Balance and Power Ram Adjustment With Lockout Valve (160/200 Ton)
- Air Line Filter, Regulator and Lubricator



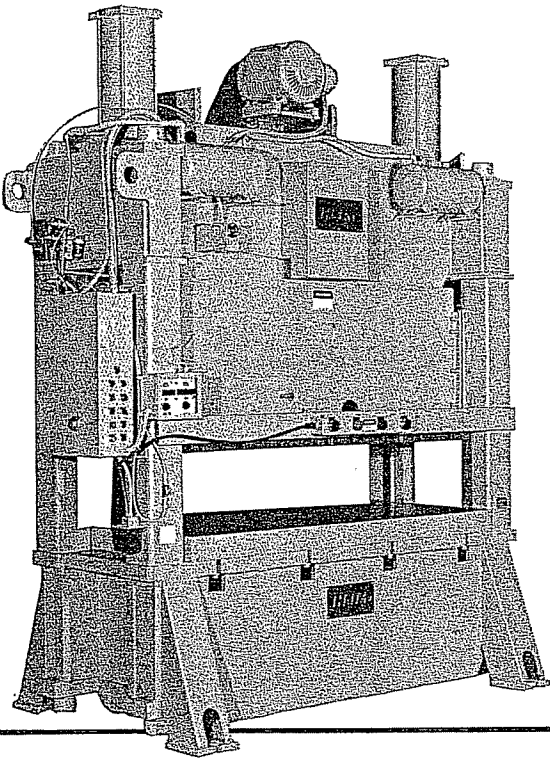
STRAIGHT SIDE PRESSES

150 Ton to 300 Ton

Featuring Hi-Tech CNC Controls For Reliable Press Operation

Standard Features

- New PC Control
- One Operator Station (Inching, Single Stroke and Continuous)
- Magnetic Starter (Non Rev.) Including Disconnect Switch With Circuit Breaker
- Complete Flywheel, Motor, Guards, Pulley V Belts and Brackets (Fully Mounted)
- Automatic Lubrication-Self Monitoring
- Power Ram Adjustment With Indicator
- Part Revolution, Low Inertia Air Clutch and Dual Caliper Disc Brake
- Double Wall Bed Construction
- Dead Motor Inch Control
- Brake Monitor
- 8 Point Adjustable Gibbing
- Tie Rod Construction
- Air Line Filter, Regulator and Lubricator

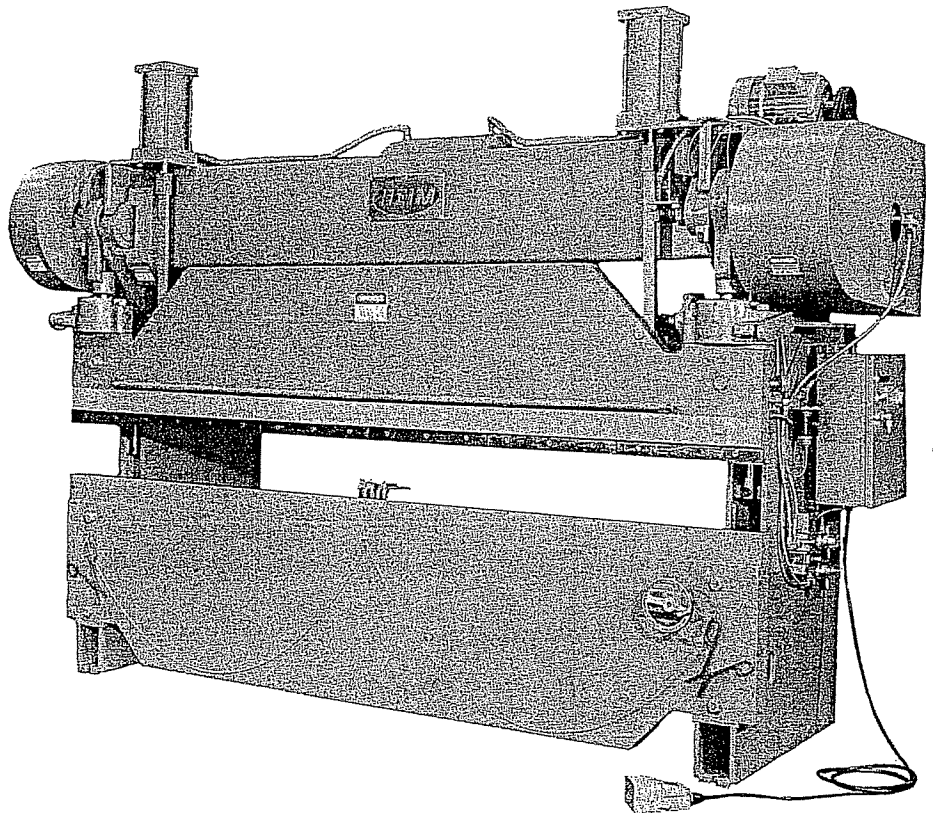


MORE PRESS FOR LESS

HEIM**HEIM****HEIM****HEIM****HEIM****HEIM****HEIM**

PRICE LIST

MECHANICAL PRESS BRAKES



HEIM CORPORATION
Frankfort, Illinois 60423 • Phone: 815/469-2335

RECEIVED JUN 29 1981

Price List Heim Press Brakes

CAPACITY TONS		35 TON			45 TON				75 TON			
LENGTH OF BED AND RAM		4'6"	6'6"	8'6"	4'6"	6'6"	8'6"	10'6"	6'	8'	10'	12'
DISTANCE BETWEEN HOUSINGS		38"	62"	86"	38"	62"	86"	110"	52"	76"	100"	124"
STANDARD PRESS BRAKE PRICE		13,700	14,200	14,805	15,310	15,800	16,240	17,180	20,940	21,415	21,830	22,450
ONE SHOT LUBRICATION		195	195	195	STD	STD	STD	STD	STD	STD	STD	STD
AUTOMATIC LUBRICATION		315	315	315	315	315	315	315	315	315	315	315
RAM INDICATORS		260	260	260	STD	STD	STD	STD	STD	STD	STD	STD
POWER RAM ADJUSTMENT		480	480	480	STD	STD	STD	STD	STD	STD	STD	STD
STROKE CHANGE OTHER THAN STANDARD	2"	STD	STD	STD	STD	STD	STD	STD	-	-	-	-
	3"	315	315	315	315	315	315	315	STD	STD	STD	STD
	4"	385	385	385	385	385	385	385	460	460	460	460
	5"	500	500	500	500	500	500	500	630	630	630	630
	6"	NA	NA	NA	NA	NA	NA	NA	880	880	880	880
REVERSING STARTER		315	315	315	315	315	315	315	385	385	385	385
MANUAL FRONT OPERATED BACK GAUGE		905	905	905	905	905	905	905	975	975	975	975
AIR COUNTERBALANCES		1250	1250	1250	1250	1250	1250	1250	1250	1250	1250	1250
MACHINING BED AND RAM FOR ANGLES**		565	625	740	565	625	740	835	625	740	835	905
SET OF FOUR 5-1/2" ANGLES		975	1490	1970	975	1490	1970	2330	1490	1970	2330	2705
SET OF FOUR 7-1/2" ANGLES		-	-	-	-	-	-	-	-	-	-	-
SPECIAL ONE COLOR PAINT PAINT FURNISHED BY CUST. PAINT FURNISHED BY HEIM		110 140	110 140	110 140	110 140	110 140	110 140	110 140	140 175	140 175	140 175	140 175
CONTROL VARIATIONS PALM BUTTONS IN PLACE OF FOOT SWITCH FT. SWITCH & PALM BTNS. WITH KEY SELECTOR SWITCH		290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485
SHIPPING WEIGHT APPROX. POUNDS		4,000	4,900	5,800	4,500	5,400	6,500	7,500	8,200	9,700	11,600	13,600

*AIR COUNTERBALANCES RECOMENDED
 **REQUIRES ONE SET OF PALM BUTTONS

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100 TON				150 TON				200 TON			
6'	8'	10'	12'*	6'6"	8'6"	10'6"*	12'6"*	6'6"	8'6"	10'6"*	12'6"*
52"	76"	100"	124"	54"	78"	102"	126"	53"	77"	101"	125"
21,415	21,830	22,450	23,675	30,505	31,230	31,870	33,525	34,250	36,630	37,765	39,525
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
315	315	315	315	315	315	315	315	315	315	315	315
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
-	-	-	-	-	-	-	-	-	-	-	-
STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD	STD
460	460	460	460	550	550	550	550	550	550	550	550
630	630	630	630	740	740	740	740	740	740	740	740
880	880	880	880	985	985	985	985	985	985	985	985
385	385	385	385	505	505	505	505	505	505	505	505
975	975	975	975	975	975	975	975	975	975	975	975
1250	1250	1250	1250	1560	1560	1560	1560	1560	1560	1560	1560
625	740	835	905	715	805	900	975	715	805	900	975
1490	1970	2330	2705	-	-	-	-	-	-	-	-
-	-	-	-	1800	2425	2985	3550	1800	2425	2985	3550
140 175	140 175	140 175	140 175	175 210	175 210	175 210	175 210	175 210	175 210	175 210	175 210
290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485	290 485
10,500	11,800	13,500	17,000	17,000	19,000	21,500	24,000	20,000	22,000	24,500	28,500

STANDARD EQUIPMENT, PRESS BRAKES

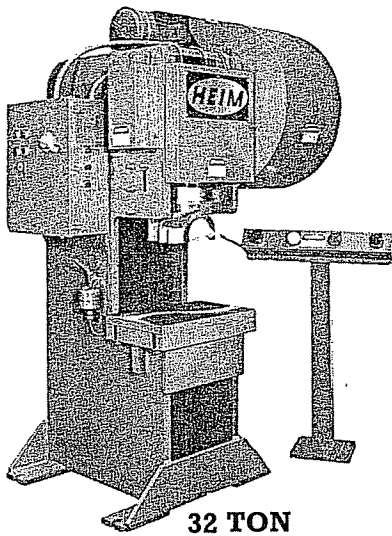
ALL MODELS: Combination air clutch and brake. Dual valve press brake control (TRU-KON-TROL) with foot pedal. Control has "stop before work", "timed automatic jog through work", and "stop on top" features. Complies with B11.3, Section 4, Standards. Nema type I combination motor starter (with 3 heater coils) and integral fused disconnect with provisions for locking in "OFF" position. Push buttons in cover with protective shroud. Electrics are set up for 220/440/3/60. Other voltages extra. Also includes drive motor, belts, pulley, manual back gauge, lower die block, air line oiler and filter and gear and flywheel guards.

45 TON:
THRU
200 TONS:

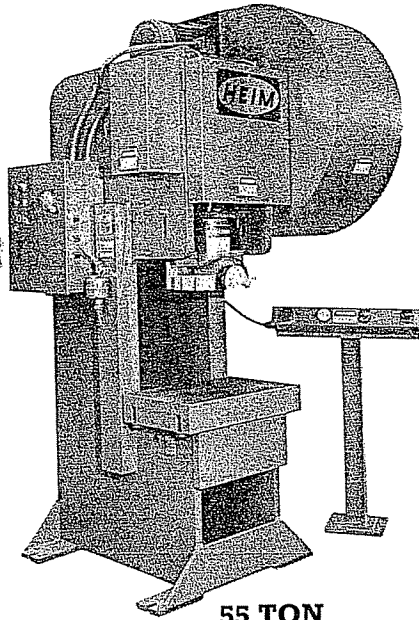
Power Ram Adjustment Ram Indicators One Shot Lubrication

OTHER HEIM PRESSES

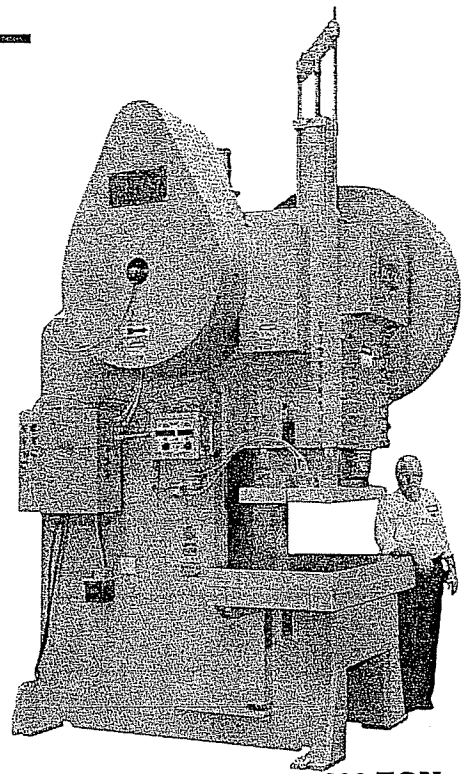
OBI, GAP and DEEP THROAT GAP PRESSES



32 TON

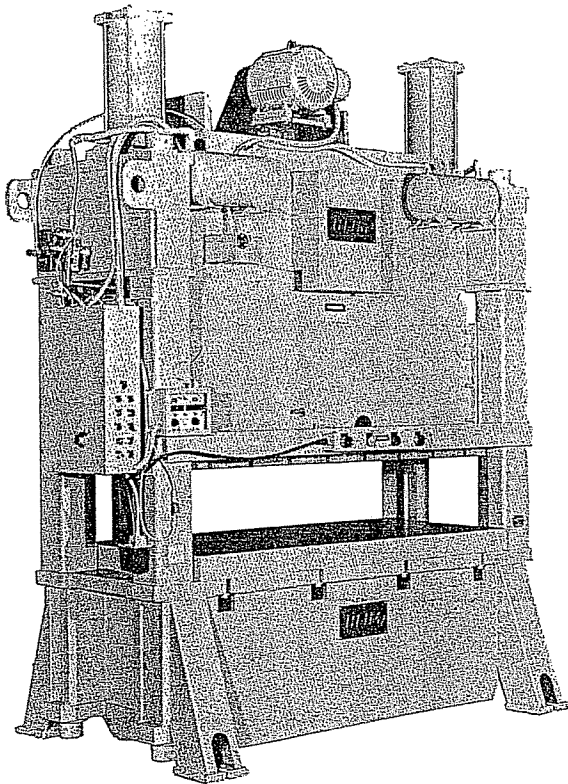


55 TON



200 TON

STRAIGHT SIDE PRESSES



HEIM Double Crank Straight Side Presses are ruggedly constructed to meet the rigid performance requirements of today's stamping operations. They retain the characteristic Heim clean-cut profile, free of protruding gears or shafts.

The high tensile drive gears in Heim Presses are housed inside the crown, with close-up support on both sides. This eliminates shaft distortion stresses often encountered in conventional press construction.

All Heim Presses have heavy duty two-point balanced gear drive, air clutch and disc brake as standard equipment. There are fewer moving parts in these presses, and all parts are better protected.

An unusual feature of Heim Presses is that the ram is always 100% guided throughout the entire stroke by eight-point adjustable gibbing.

CONTACT: Forrest Tower, Vice President, General Sales Manager, for more information!

*Prices and delivery subject to change

**STRAIGHT
SIDE PRESSES**
150 Ton to 400 Ton



HEIM CORPORATION

Frankfort, Ill. 60423 · Phone: (815)469-2335

②

A-470

ANTI-TRIP FOOT CONTROL
 CAT. #511-B2 (LIFE MASTER)
 STAGE: SINGLE-DPDT
 RATING: 20 AMP, 125-250 VAC

A-470-D

ANTI-TRIP FOOT CONTROL
 CAT. NO. 532-SWH 511-B4
 STAGE: SINGLE - DPDT-DB
 RATING: 20AMP 125-250 U.A.C. - 15 AMP
 WOODSTOCK CONNETICUT

DEALER: LINEMASTER SWITCH CORP.
 WOODSTOCK, CONN. 06281

2	12/1/74	P. 3	ADD PART A-470	00039
1	11/9/74	P. B	511-B4 WAS 532-SWH, ADD DB	00037

HEIM CORP.
 P. O. BOX R
 FRANKFORT, ILL. 60423

DRAWN BY	DATE	CHECKED BY	DATE	SCALE
BH	7-9-74			

DESCRIPTION

ELECTRIC FOOT CONTROL

USED ON

ALL PRESSES

PART NO.

A-470-D

10/05/2005 14:45 7084967428

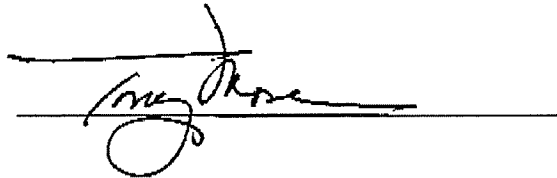
HEIM

PAGE 02/02

VERIFICATION

I, Tony MAGE, am the NATIONAL Sales Manager of HEIM, L.P., and state that the averments of fact set forth in the foregoing *ANSWERS TO PLAINTIFF'S INTERROGATORIES - SECOND SET AND REQUEST FOR PRODUCTION OF DOCUMENTS - SECOND REQUEST* are true and correct to the best of my knowledge, information, and belief.

I understand that the statements herein are made subject to the penalties of 18 Pa.C.S.A. § 4904 relating to unsworn falsification to authorities, which provides that if I make knowingly false averments I may be subject to criminal penalties.

Date: 10/5/05.A handwritten signature in black ink, appearing to read "Tony Mage", is written over a horizontal line.

File No: ALFA-107530/PRR

PROOF OF SERVICE

This is to certify that a true and correct copy of the foregoing document has been served upon all parties on the date and in the manner listed below:

<u>X</u>	First Class Mail, Postage Prepaid
<u> </u>	Certified Mail - Return Receipt Requested
<u> </u>	Hand Delivery
<u> </u>	Facsimile Transmission

at the following address:

Dallas W. Hartman, Esquire
Dallas W. Hartman P.C.
2815 Wilmington Road
New Castle, PA 16105
(Counsel for Plaintiff)

MEYER, DARRAGH, BUCKLER,
BEBENEK & ECK, P.L.L.C.

Date: 10-6, 2005



PAUL R. ROBINSON, ESQUIRE